

Date: Wednesday, 3/8/2006 10:31:15 AM
 User: Kim Johnston

Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 26095
 Estimate Number : 10265
 P.O. Number : *N/A*
 This Issue : 3/8/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LANDING GEAR
 Previous Run : 26094
 Part Number : D350636012
 Drawing Number : D2750 REV C1
 Project Number : N/A
 Drawing Revision : C1
 Material : *SLM*
 Due Date : 4/15/2006 Qty: 1 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.03.08*
 Comment : Est Rev: 02.09.25 Rearranged procedure steps KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B25384 Pm'06-03-10

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap

B24672 BE 06-04-05

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end *Pm'06-03-10*

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 *Pm'06-03-10*

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size *Pm'06-04-04*

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig *Pm'06-04-04*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 26095

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8329

Make sure that wearplate holes are on bottom of tube**

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375" as per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .590" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M1910 BE 06-04-05 (1)

13-Grind welds flush as per Dwg D2750

BE 06-04-06 (1)

Pm' 06-04-04 (1)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm' 06-04-06 (1)

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

DD 4-6 / PD 06-4-06

1

7.0

D2739

350 Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

B 26385

Pm' 06-04-07 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D350636012

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Seq. #: Machine Or Operation: Description:

8.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit / Total: 8.0000 Each(s),

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

24240 BE 06-04-11 (1)

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil

2-Deburr and blow out all chips from inside of tube

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

Sikaflex expire date: 06-11-01

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

5-Grind welds flush as per Dwg D2750

6-Spot face ground handling holes AE0.750" (8 places)

7-Deburr holes

10.0 QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

Dart Aerospace Ltd

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Part Number: D350636012

Job Number:



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|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|-------------------|
| 13.0 | D27422 | Blade Fitting, RH |
|------|--------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------------|--------|
| 1 | D2742-2 | Blade Fitting, LH | B24640 |

| | | |
|------|--------|------|
| 14.0 | AN835A | Bolt |
|------|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | AN8-35A | Bolt | M18576 |

| | | |
|------|------------|-------------------|
| 15.0 | AN960JD816 | 1/2" washer, Alum |
|------|------------|-------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | AN960JD816 | Washer | M6956 |

| | | |
|------|-----------|-----|
| 16.0 | MS21083N8 | Nut |
|------|-----------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | MS21083N8 | Nut | M19185 |

| | | |
|------|--------|---------|
| 17.0 | D26483 | Wearpad |
|------|--------|---------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 5 | D2648-3 | Wearpad | B24843D2 |

| | | |
|------|---------|-----------|
| 18.0 | D265613 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2656-13 | Wearplate | B25329 |

DL 06/05/01

(1)

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26095

Part Number: D350636012

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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| | | |
|------|---------|-----------|
| 19.0 | D265635 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 1 | D2656-35 | Wearplate | B25330 ✓ |

| | | |
|------|-------|----------|
| 20.0 | D2746 | Wearshoe |
|------|-------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 1 | D2746 | Wearplate | B27149 ✓ |

| | | |
|------|-------------|--------|
| 21.0 | ALS41032225 | Insert |
|------|-------------|--------|



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|--------------------|-----------------|-------------|----------|
| 46 | ALS4-1032-225 ✓ | Insert | M18293 ✓ |
| (or AKS4-1032-225) | | | |
| (or ALS7-1032-225) | | | |
| (or AKS7-1032-225) | | | |

| | | |
|------|------------|--------|
| 22.0 | AN960JD10L | Washer |
|------|------------|--------|



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------------------|
| 42 | AN960JD10L | Washer | 19X M19185 23X M18235 ✓ |

| | | |
|------|-------|------|
| 23.0 | AN35A | Bolt |
|------|-------|------|



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 38 | AN3-5A | Bolt | M15205 |

DC 06/05/01

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26095

Part Number: D350636012

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

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|------|-------|------|
| 24.0 | AN36A | Bolt |
|------|-------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-----------|
| 4 | AN3-6A | Bolt | M100274 / |

| | | |
|------|-------|---------|
| 25.0 | D2745 | Bushing |
|------|-------|---------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 8 | D2745 | Bushing | B24879 / |

| | | |
|------|--------|------|
| 26.0 | AN644A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 4 | AN6-44A | Bolt | M19073 / |

| | | |
|------|-----------|-----|
| 27.0 | MS21042L6 | Nut |
|------|-----------|-----|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 4 | MS21042L6 | Nut (or -6) | M17614 / |

| | | |
|------|--------|------|
| 28.0 | AN332A | Bolt |
|------|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 4 | AN3-32A | Bolt | M18906 |

DC 06/05/01 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 26095

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 A3235020935 Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|---------------|-------------|----------|
| 8 | A3235-020-935 | Plug | M18369 ✓ |

30.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 4 | MS21042L3 | Nut | M6931 ✓ |

31.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-----------|
| 4 | AN3-6A | Bolt | M100274 ✓ |

32.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 4 | AN960JD10 | Washer | M16066 |

PC 06/05/01 (1)

33.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 M100480

Sikaflex expire date: 11/09

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 M100480

Sikaflex expire date: 11/09

PC 06/05/01 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
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3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

DL 06/09/01 (1)

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 06 05 02 (1)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

B25938 /

37.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

M6956 /

38.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

M19099 /

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

MS760

AP 06/05/02 (1)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AP 06/05/02 (1)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

REVD

AP 06/05/02 (1)

42.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AP 06/05/03 (1)

Job Completion



U 06.05.03

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



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| DESIGN <i>DAH</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED <i>DAH</i> | APPROVED <i>KE</i> | DRAWING NO. D2750 | REV. C SHEET 1 OF 4 |
| DATE 98.11.18 | | TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.09.01 | CHANGE MS24694-S293 TO AN8-16A | |
| C | 98.11.18 | ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740 | |
| CI | <i>CP</i> 05.01.20 | CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED | |

RELEASED
98.12.16 DS

| Qty -041 | Qty -042 | Qty -043 | Qty -044 | Part Number | Description |
|---------------------|---------------------|---------------------|---------------------|---|-----------------------|
| X | | | | D2750-041 | SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | SKIDTUBE ASSEMBLY, RH |
| 3 | 3 | 3 | 3 | D2648-3 | WEARPAD |
| 2 | 2 | 2 | 2 | D2648-5 | WEARPAD |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 1 | 1 | 1 | 1 | D2741 | BLADE |
| 1 | | 1 | | D2742-1 | BLADE FITTING, LH |
| | 1 | | 1 | D2742-2 | BLADE FITTING, RH |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 8 | 8 | | | A3235-020-935 | PLUG |
| 40 | 40 | 40 | 40 | AN3-5A | BOLT |
| 8 | 8 | 8 | 8 | AN3-6A | BOLT |
| 4 | 4 | | | AN3-32A | BOLT |
| 4 | 4 | 4 | 4 | AN6-44A | BOLT |
| 2 | 2 | 2 | 2 | AN8-16A | BOLT |
| 1 | 1 | 1 | 1 | AN8-35A | BOLT |
| 3 | 3 | 3 | 3 | MS21083N8 | NUT |
| 4 | 4 | | | MS21042L3 OR MS21042-3 | NUT |
| 4 | 4 | 4 | 4 | MS21042L6 OR MS21042-6 | NUT |
| 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 44 | 44 | 44 | 44 | AN960JD10L | WASHER |
| 4 | 4 | 4 | 4 | AN960JD816 | WASHER |
| 44 42 | 44 42 | 44 42 | 44 42 | ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225 | INSERT |

| | |
|-------------|-------------|
| EFFECTIVE | DEOS |
| D20 4133 DS | D20 4157 DS |
| 98.01.19 DS | 99.10.21 DS |

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NO. *26095*



| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>JA</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED <i>JA</i> | APPROVED <i>LE</i> | DRAWING NO. D2750 | REV. C SHEET 2 OF 4 |
| DATE 98.11.18 | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE NTS |

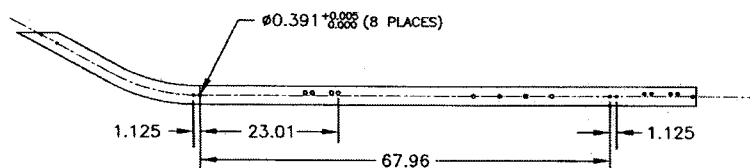
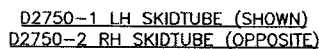
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

| EFFECTIVE | DEOs |
|-------------------------|-------------------------|
| DEO 4133 98.01.19 DS | DEO 4157 99.10.21 DS |
| | |

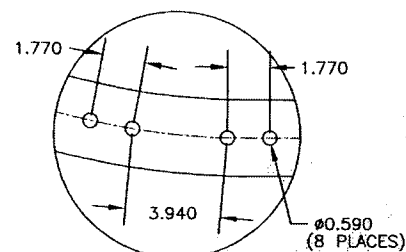
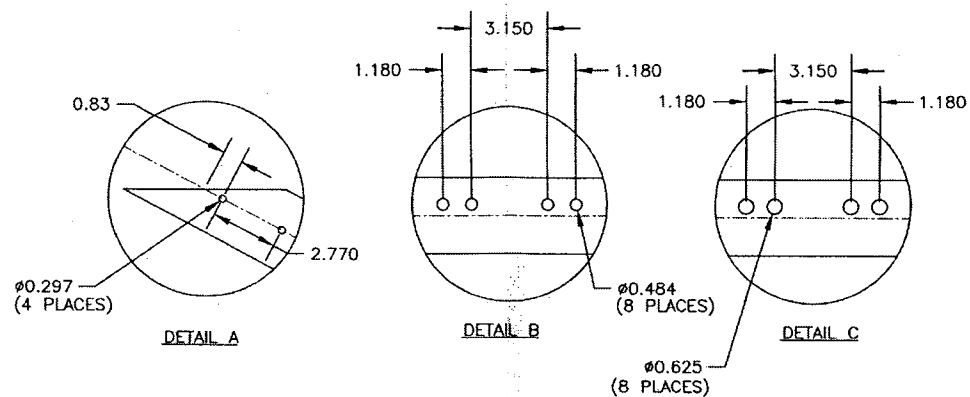
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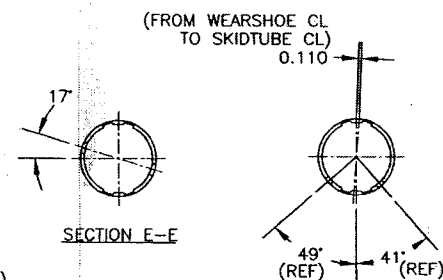


D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)

D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.




DETAIL D
(ALL DIMENSIONS ARE
STRAIGHT LINE DIMENSIONS)



SECTION F-F

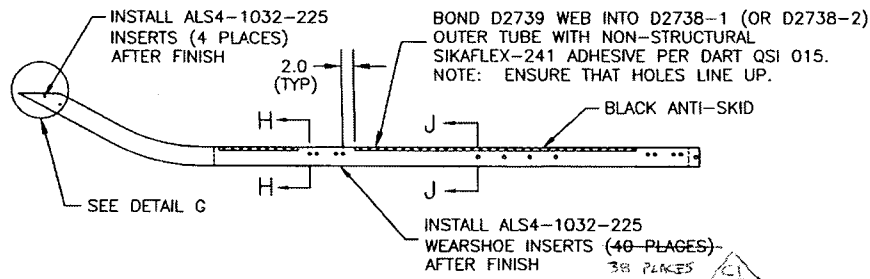
RELEASE
98.12.16 DS

| EFFECTIVE | DEOs |
|-------------------------|-------------------------|
| 000 4133 98.01.19 DS | 000 4137 99.01.21 DS |
| | |

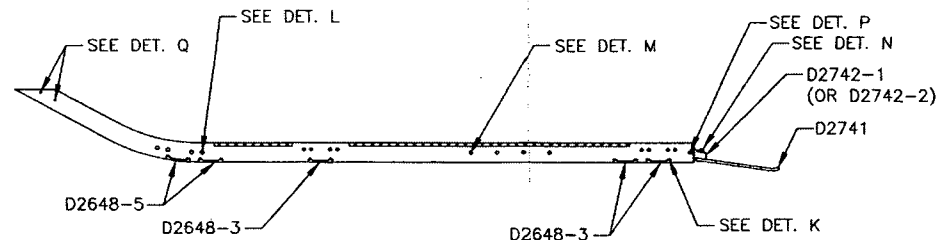
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| DESIGN #1 | DRAWN BY CP |  DART AEROSPACE USA, INC. BELLUVE, WA | REV. C |
| CHECKED POT | APPROVED HE | | DRAWING NO. D2750 |
| DATE 98.11.18 | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE 1:20 |

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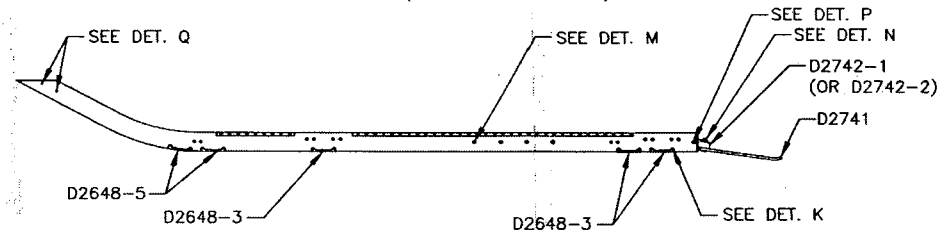
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



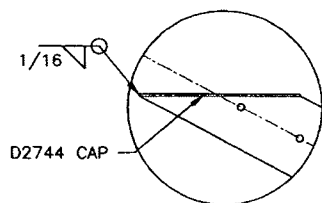
D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



DETAIL G



SECTION H-H

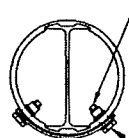


SECTION J-J



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

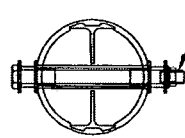
DETAIL K



USE AN3-6A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD

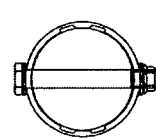
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)

DETAIL M



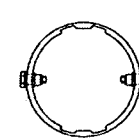
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)

DETAIL P



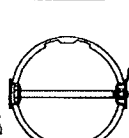
AN8-35A BOLT (1)
AN960JD816 WASHER (2)
MS21083N8 NUT (1)

DETAIL Q



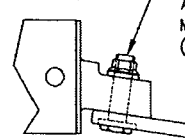
AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)

DETAIL L



AN3-32A BOLT (1)
A3235-020-935 PLUG (2)
MS21042L3 NUT (1)
(4 PLACES, FOR
D2750-041/-042 ONLY)

DETAIL N



AN8-16A BOLT (1)
AN960JD816 WASHER (1)
MS21083N8 NUT (1)
(2 PLACES)

| EFFECTIVE | DEOs |
|-------------------------|-------------------------|
| 180 9133 98.01.19 DS | 180 9157 99.10.21 DS |

| | | | |
|--------------------------|---------------------------|--|----------------------|
| DESIGN 98 | DRAWN BY 98 | DART DART AEROSPACE USA, INC. BELLINGHAM, WA | REV. C |
| CHECKED 98 | APPROVED KE | | DRAWING NO. D2750 |
| DATE 98.11.18 | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE 1:20 |

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